

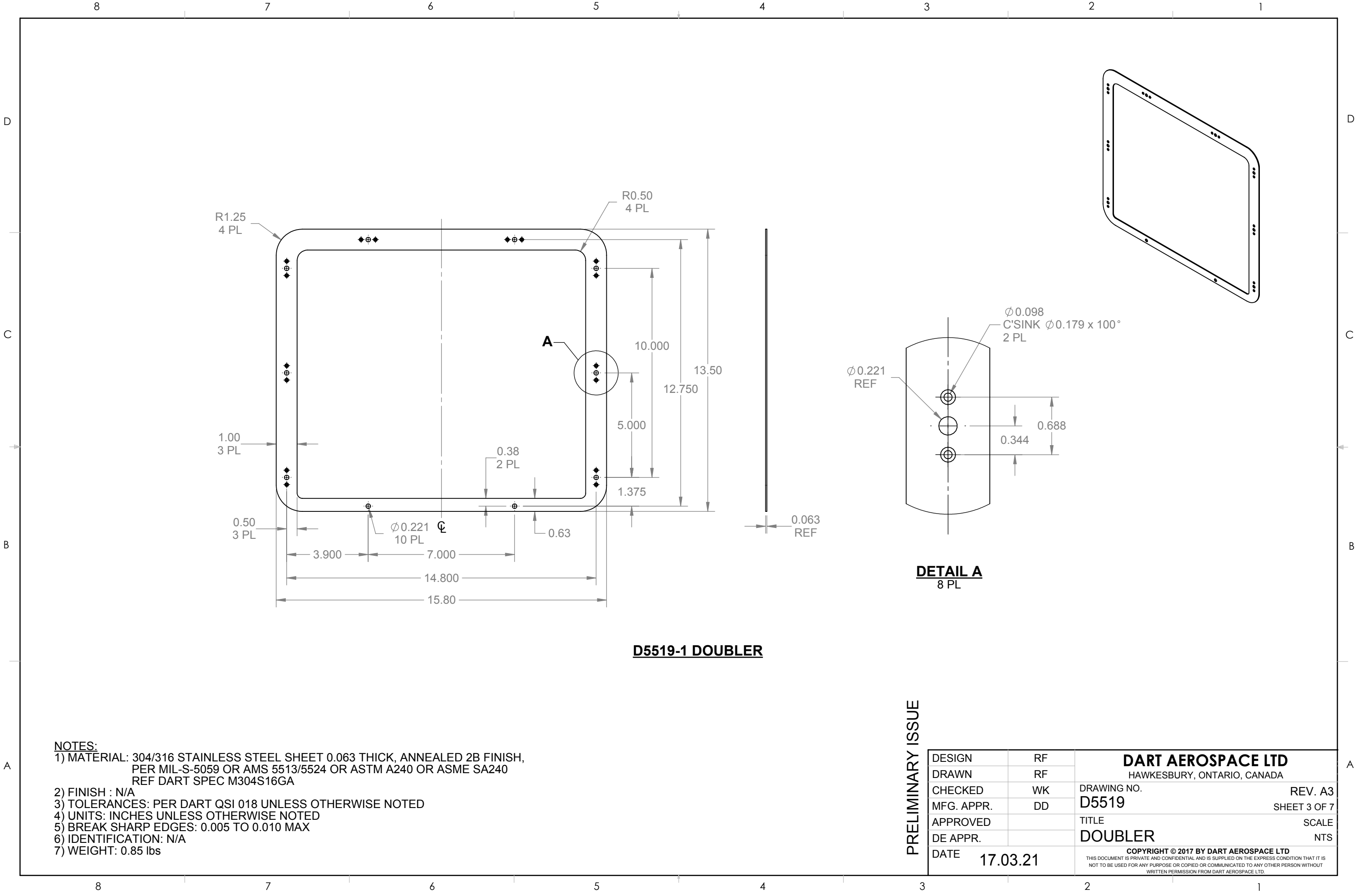
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
7) WEIGHT: 0.88 lbs
8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5519-041	DOUBLER ASSEMBLY
1	1	D5519-1	DOUBLER
2	2	D5519-5	PACKER
3	16	MS20427F3-(3)	RIVET, SOLID, CSK
4	8	MS21059L3	NUT PLATE

D5519-041 DOUBLER ASSEMBLY

PRELIMINARY ISSUE

A	NEW ISSUE	RF	17.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5519	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	17.03.21	COPYRIGHT © 2017 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

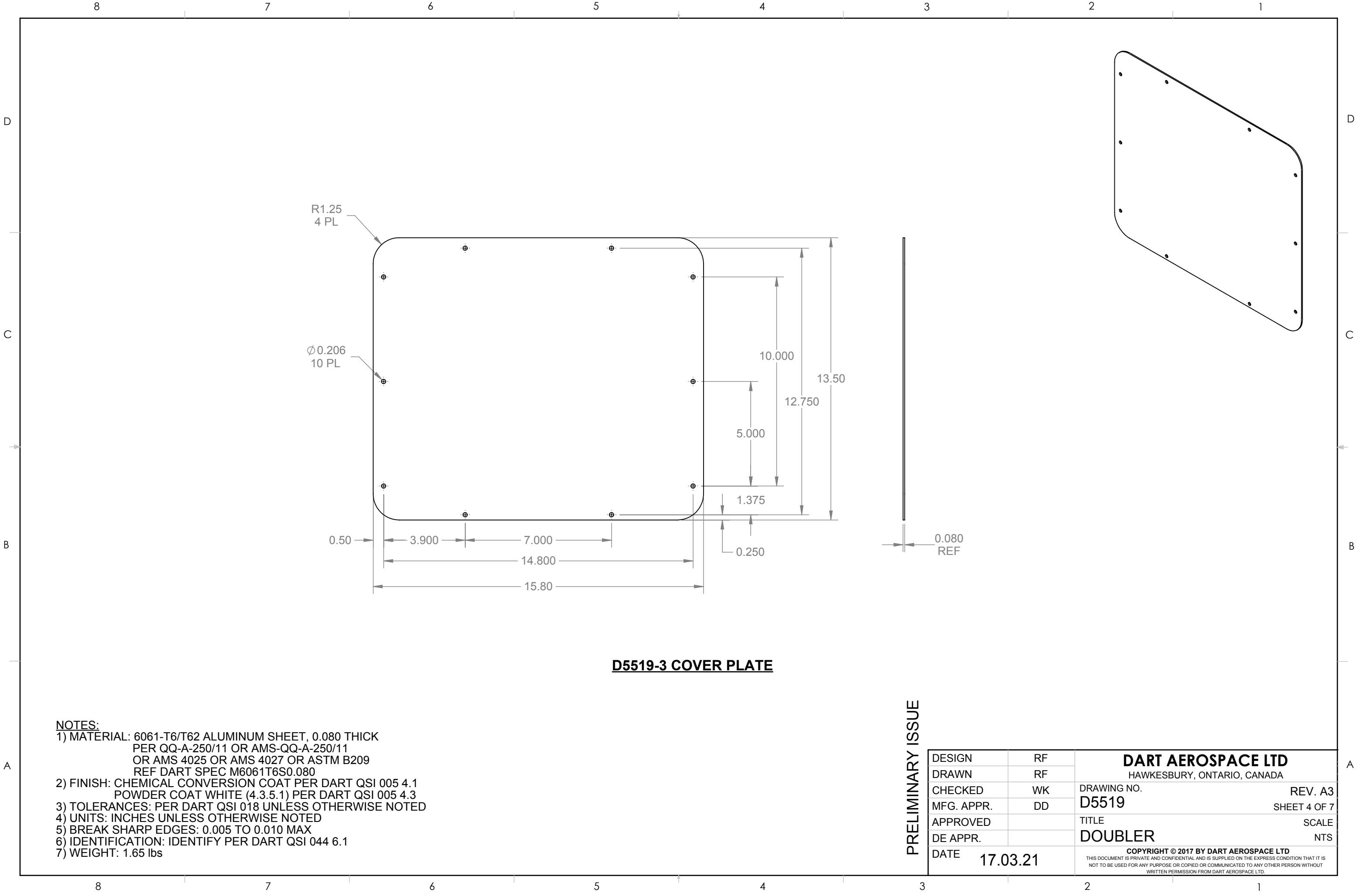


D5519-1 DOUBLER

- NOTES:
- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET 0.063 THICK, ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
 - 2) FINISH : N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.85 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5519	REV. A3 SHEET 3 OF 7
MFG. APPR.	DD		
APPROVED		TITLE DOUBLER	SCALE NTS
DE APPR.			
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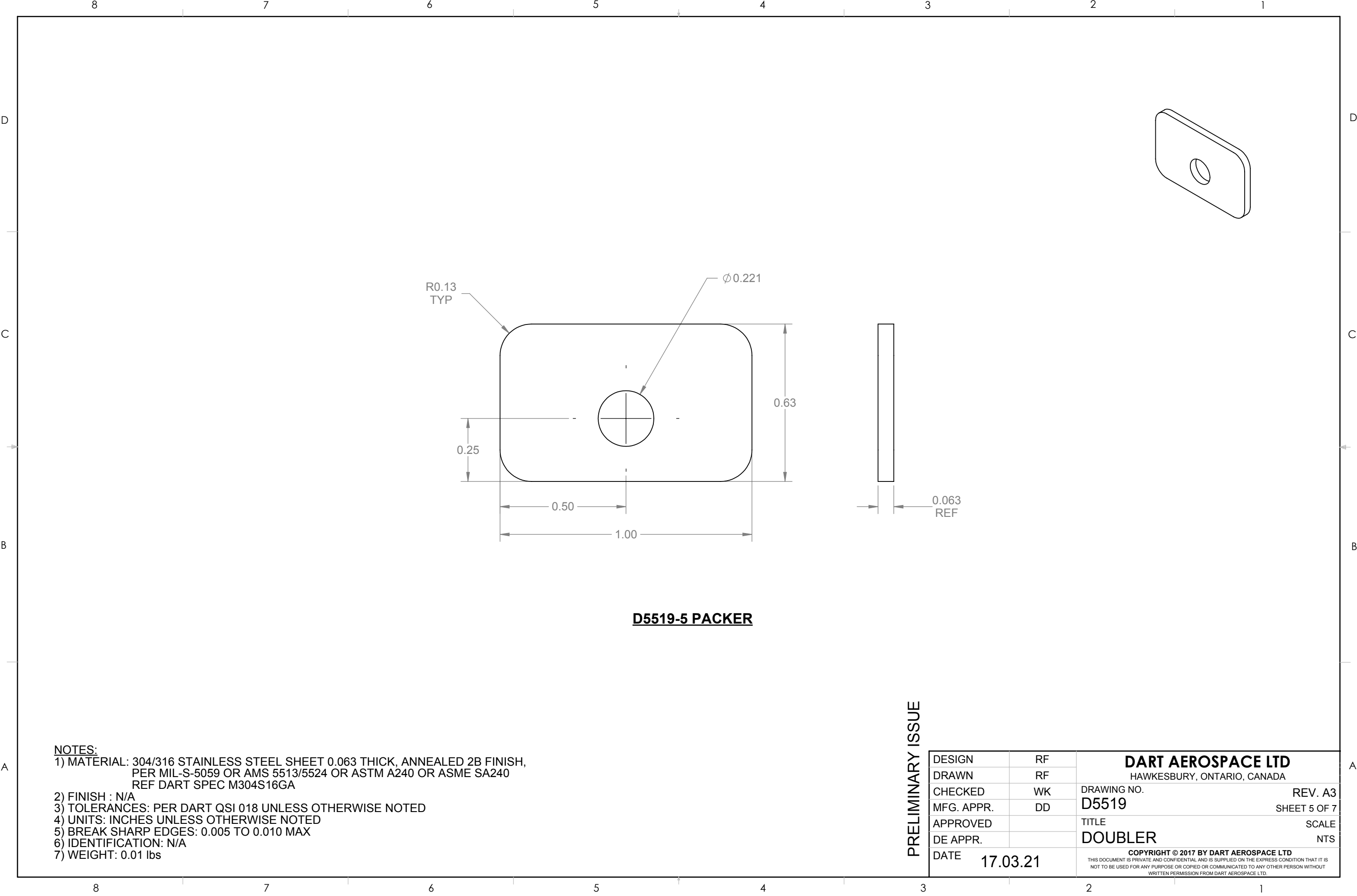


D5519-3 COVER PLATE

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S0.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.65 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5519	REV. A3 SHEET 4 OF 7
MFG. APPR.	DD		
APPROVED		TITLE DOUBLER	SCALE NTS
DE APPR.			
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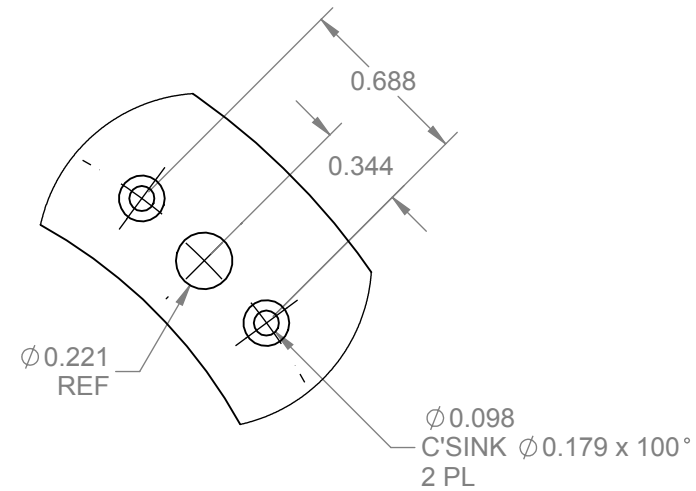
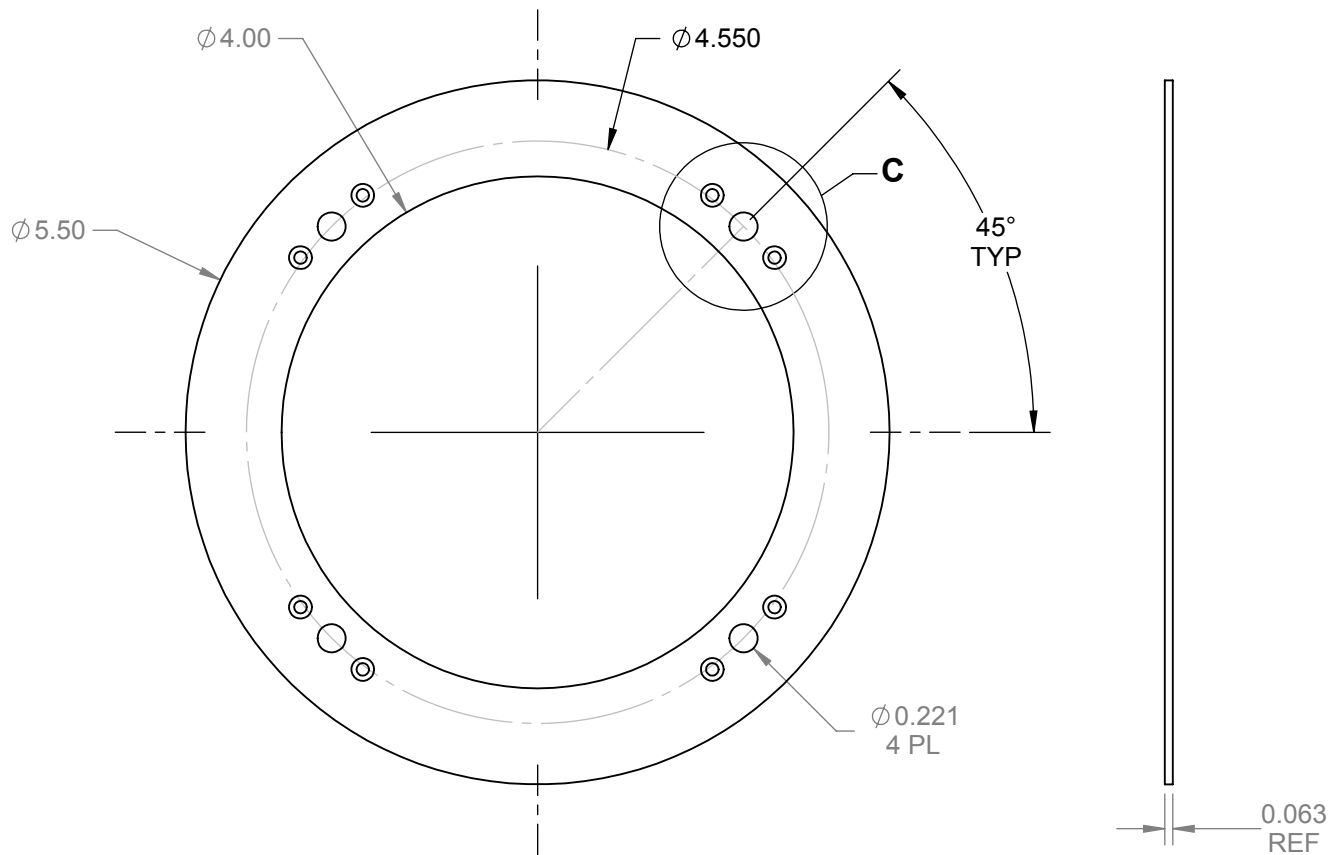


D5519-5 PACKER

- NOTES:
- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET 0.063 THICK, ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
 - 2) FINISH : N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5519	REV. A3
MFG. APPR.	DD	SHEET 5 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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DETAIL C
4 PL

D5519-7 DOUBLER

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET 0.063 THICK, ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
- 2) FINISH : N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5519	REV. A3
MFG. APPR.	DD	SHEET 6 OF 7	
APPROVED		TITLE DOUBLER	SCALE NTS
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DATE	17.03.21		

